

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019872**Date Inspected:** 20-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations relative to the work being performed.

**OBG Segment Name:** 9BW / North of Bay 19

This Caltrans QA inspector observed Flux Cored Arc Welding (FCAW) in progress. Welder is identified as #045143 welding a Fillet Weld (FW) identified as #SSD11A-PP75-014 in the 2F position using Welding Procedure Specification (WPS), WPS-B-T-2132. ZPMC QC inspectors are identified as Mr. Wang Wei Ming and Certified Welding Inspector (CWI), Mr. Li Yan Hua. The welding variables recorded by QC appeared to comply with the WPS.

**Segment Name:** 7EW + 9DE / North of Bay 14

This Caltrans QA Inspector observed that ZPMC CWI and/or ZPMC Quality Control (QC) Inspectors were not present during the welding operations North of Bay 14 during the time of QA observations from 09:30 to 10:10 hours. This time frame exceeds the allowable maximum time for QC Inspection coverage as required by Caltrans Special Provision Section 8-3.01. "QC inspections shall be provided to ensure continuous inspection when any welding is being performed. Continuous inspection, as a minimum, shall include (1) having QC Inspectors continually present on the shop floor or project site when any welding operation is being performed, and (2) having a QC Inspector within such close proximity of all welders or operators so that inspections by the QC Inspector of each operation, at each welding location, shall not lapse for a period exceeding 30 minutes." This QA inspector generated a Quality Assurance-Incident Report this date. See Incident Report dated 12-20-09 for additional information.

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## WELDING INSPECTION REPORT

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OBG Segment Name: 11CE / Bay 13

This Caltrans QA inspector observed Shielded Metal Arc Welding (SMAW) in progress. Welder is identified as #200113 welding FW repair in the 4G position using welding procedure specification

WPS-345-SMAW-4G(4F)-FCM-Repair. The weld is identified as SSD20-PP101-232. ZPMC QC inspectors are identified as Mr. Guo Xing Hui and CWI, Mr. Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 8AE / Blast Shop

This Caltrans QA Inspector performed a preliminary random visual inspection after the grit blast of the internal components of the bottom floor plates, side plates, lower floor beam and longitudinal beam, between panel points PP63 and PP64 assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

“As noted within the contents of this report.”

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley, Ken	QA Reviewer

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